

CLAIMS

1. An injection-molding method in which plastic material under pressure is injected from an antechamber (1) which can be shut off, into a mould cavity (3) after opening of a shut-off means (2), and fills the mould cavity under pressure, characterised in that the volume of the antechamber (1) and the pressure prevailing therein, at the opening of the shut-off means (2), are of values, at the existence of which at least half of the pressure achieved in the mould cavity (3) in the method occurs even if the volume of the antechamber (1) is kept constant during the injection operation.

2. A method according to claim 1 characterised in that the pressure in the antechamber (1) at the opening of the shut-off means (2) is over 1000 bars and preferably over 1500 bars.

3. A method according to claim 1 or claim 2 characterised in that the volume of the antechamber (1) at the opening of the shut-off means (2) is at least twice as great as the volume which is downstream of the shut-off means (2) and which includes the mould cavity (3).

4. A method according to one of claims 1 to 3 characterised in that the volume of the antechamber (1) is kept constant during the injection operation so that the total pressure in the mould cavity (3) is produced by expansion of the plastic material which initially fills only the antechamber (1).

add A2